

Friday, July 28, 2017 8:33:39 AM

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Stop *NR2*

Draw Nbr	Revision Nbr
D3859	B

0.00

0.41

Memo

1-Cut as per Dwg D3859-1

Dwg Rev: 13

Prog Rev: 3

2-Deburr if necessary

0.00

QC2- Inspect parts off machine FAI/FAIB

0.04

Memo

Quality Control

0.00

QC8- Inspect parts - second check

0.08

QC

Memo

Quality Control

Work Order ID 164708***164708***

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Item ID: D3859-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 8/30/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/5/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M136585</u> Large Fab Memo 1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod *****use DT9462 for welding***** 1- WELD HARDCOAT TO BAR 2059B HARDCOAT BATCH: <u>M132339</u>	0.00 2.16				<u>4</u>		<u>DK</u> <u>17/08/28</u>	
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>4</u>	<u>17-08-29</u>		<u>DAS</u> <u>9</u> <u>9-89</u>
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				<u>4</u>	<u>17-08-29</u>		<u>DAS</u> <u>9</u> <u>9-89</u>

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AUG 30 2017

Picklist Print

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Page 1

Work Order ID: 164708

164708

Parent Item: D3859-041

D3859-041

Parent Item Name: Wearplate Assembly

Start Date: 8/30/2017

Required Date: 9/5/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC
14.04.30 as per dwg rev.b DD verified by:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4379-5

Manufactured

No

130

Each

66.0000

6

24

D4379-5

Wearplate Cup

**

D4C 17/08/28

Location

Loc Qty

Loc Code

WA001

66

6

160619

36

18

163974

30

M304S16GA

Purchased

No

100

sf

77.2920

0.85

3.4

M304S16GA

304/316 Sheet .063

**

17/08/11

DAS
40
9-89

Location

Loc Qty

Loc Code

MAT010

77.292

m136896

0.3

m137110

0.132

m137175

1.1

m137341

2.62

m137400

3.9

m137844

5.24

m138109

64

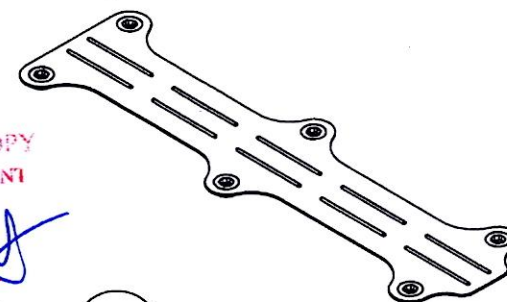
3.5

ITEM NO.	QTY.	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP

△ B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164708

JUL 28 2017



2059B HARDCOAT
10 PL

0.06
TO
0.13
HIGH

C
SYM

0.38

1.0
TYP

3.1
TYP

1.50
REF

1.00

HARDCOAT WELD
SURFACING
REF

6 PL

1/32

6

D3859-1 WEARPLATE (1)

INSTALL D4379-5 FLUSH
WITH THIS SURFACE
TYP

D4379-5 WEARPLATE CUP (6) △ B

D3859-041 WEARPLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

RELEASED

2014 MAR 29

ECN 14-544

APPROVED

B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	09.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.03.05		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3859

REV. B

SHEET 1 OF 2

TITLE

WEARPLATE

SCALE

NTS

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